HAAS 1 --.

HAAS CNC vertical machine #1

October-17-13 1:30:22 PM Accept *N900040100* Item ID: Setup Start **Revision ID:** Item Name: Eyebolt Block *12* **Start Qty: 12.00** Start Date: **Cust Item ID:** 10/17/13 Req'd Oty: 12.00 Required Date: 10/17/13 **Customer:** Reference: Run Process Plan: MLJ Date: 13-10-22 Tooling: Date: Approvals: Stop Date: _____ SPC (Y/N): Date: Reject Operation Set Up/ **Tool ID** Tool # Plan Reject Insp. Sequence ID/ Accept Number Stamp Work Center ID Description **Run Hours** Code Qty Qty **Revision Nbr Draw Nbr** D3912 В Cut blanks as per folio 0.00 100 113-10-27 *100* 0.00 Bandsaw Memo CUT BLANK 2.50" LONG Jeaspa Bandsaw 0.00

0.00

13/10/29

DEBURR

FOLIO REV: AA DWG REV: B

Memo

MACHINE AS PER FOLIO FA870 AND DWG

											DQA:	Date:	
NCR: Ye	es /	/ No				WORK ORDER NON-C	100	NFORN	MANCE / UF	PDATE	QA Closed:	Date:	•
Work Order	r:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No	o					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T				Descri	ption of work order update	1	nitial	A	ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data	_	1											
Equip/Tooling													
Operator	╝	i											
Material	╝												
Setup						•							
Other	7												
Process							1						
Supplier									:				
Training													
Unapproved													
						F	AUL	T CATE	GORY				

Landing	Gear	General		_		_		_
	Bending	Bend		Grain		Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Г	Over/Under tolerance		Temperature/Cure
	Cracks	Broken/Damaged	Г	Inspection Incomplete		Part Incorrect		Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Г	Wrong Stock Pulled
	Cuffs	Contamination	Г	Maintenance		Part Moved		-
	Heat Treat	Countersink	Г	Mislabeled		Positioned Wrong		
	Inspection Strip in Tube	Cut Too Short	Г	Misread		Power Loss/Surge		Other
	Ripples in Bend	Drill Holes		Offset		•		
	Torque Waves in Extrusion	Drawing		Out of Calibration				
	Turning Sequence	Finish	Г	Out of Sequence				
	Wave/Twist in Tube	Folio	Г	Outside Dimensions				

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Work Ord October-17-13		8416		*10	184	16*							Page	2
Item ID: Revision ID: Item Name:	D3912-3 Eyebolt Block			Accept	*1	1900	040	100)*	Setup	Start Stop	*N.	S1* S2*	
Start Date: Required Date Reference:	10/17/13 : 10/17/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*			Cust Item I Customer:	D:							
Approvals:		in:	Date:	Tooling: SPC (Y/N):			ate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center I 120 *120* QC Quality Control	D	Operation Description QC2- Inspect parts off management	achine FAI/FAIB	Set Up/ Run Hours 0.00 0.00		Tool ID	Tool#	Plan Code	Accept Qty	t Rej		Reject Number	Insp. Stamp AS 08	•
130 *130* QC Quality Control		QC8- Inspect parts - seco	and check	0.00		7-10	-30		12		A			-
160		Identify as per dwg & Sto	ock Location: <u>5714</u> 4	0.00										

0.00

Memo

12 x DAS 13-10-30 28 9-89

160
Packaging

Packaging

												DQA:	Date:	r
NCR:	Yes	/ No					WORK ORDER NON-O	100	VFORM	AANCE / UP	PDATE	04 Classic	D-t	
	-					_						QA Closed:	Date:	
Work Orde	er:						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	•						Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	Vo.						Scrap]	f	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
							Use-as-is]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۷o.						Work Order Update]		Large Fab	Composite		Supplier	
Root	-			1	Des	crir	otion of work order update		nitial	Λ.	ction	Sign &		T
Cause		Date	Step	Qty	Des	•	r Non-conformance	,	ief Eng		cription	Date	Verification	QC Inspector
oc/Data	Г	Date	эсер	Qiy		_	- Hon comormance	-	iler Elig	2636	- Theren	Dute	Vermeution	Qe mapeetor
quip/Tooling								ļ						
perator														
faterial														
etup			ļ											-
ther														
rocess														
upplier	Г													
raining														
napproved														
							F	ΑUL	T CATE	GORY				
Landi	ng (Gear					General		_		_	_		_
	L	Bending					Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (O/S		BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	L	Cracks					Broken/Damaged	<u>_</u>	4	on Incomplete	Ļ	Part Incorre	ct	Weld
		Crushed/	Crimped				Burrs	L	Instruct	ions Incomplete/	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	L	Cuffs					Contamination		Mainte		L	Part Moved		
	L	Heat Trea	-		,		Countersink		Mislabe	led	L	Positioned V		,
		Inspection	n Strip in	Tube			Cut Too Short	\perp	Misread	1		Power Loss/	Surge	Other
	_	Ripples in					Drill Holes		Offset					·
		Torque W	/aves in E	xtrusion	า		Drawing		Out of (Calibration				
	1	Turning S	equence			l	Finish		lout of	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

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W	ork	0	rd	er	I	D	10841	6
_	-							

108416

Page 3

October-17-13 1:30:23 PM

Required Date: 10/17/13

Item ID:

D3912-3

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

Eyebolt Block

10/17/13

Start Qty: 12.00 Req'd Qty: 12.00

12

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

0.00

0.00

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Code

Run

Reject

Oty

Stop

Sequence ID/

Work Center ID

170

170

QC:

Operation

Description

QC21- Final Inspection - Work Order Release

Memo

Quality Control

Accept

Qty

Reject Insp.

Number Stamp

W/3-11-01 W 13-10-31

NCR:	Yes	1	No
INCK:	162	/	INO

Date:

NCR: Y	'es	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE			•
											QA Closed:	Date:	
Nork Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	lo.			_		Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	ło.					Use-as-is Work Order Update	_		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Descr	iption of work order update		Initial	Ac ⁴	tion	Sign &		
Cause		Date	Step	Qty.		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data					•								
quip/Tooling													
perator		* .					-					: 	
1aterial													
etup	_												
ther													
rocess													
upplier													
raining]						Í				
napproved							$oldsymbol{\perp}$						
			_				FAUL	LT CATE	GORY				
Landi		1			_	General	_	1			7	 -	- I
		Bending			<u> </u>	Bend	<u> </u>	Grain		:	Ovalized	_	Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route	_	Hardwa			Over/Under	<u> </u>	Temperature/Cure
		Cracks			\vdash	Broken/Damaged	_	4	ion Incomplete		Part Incorred	}	Weld
		Crushed/0	Crimped		L	Burrs	-	4	ions incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			-	Contamination	<u> </u>	Mainte			Part Moved		
		Heat Trea			L	Countersink	<u> </u>	Mislabe		<u></u>	Positioned W		,
		Inspection	-	Tube	L	Cut Too Short		Misread	ı		Power Loss/	Surge	Other
		Ripples in			L	Drill Holes		Offset					
		Torque W			י ב	Drawing	L	-	Calibration				
	<u> </u>	Turning S				Finish	\perp	Out of S	Sequence			· -	
		Wave/Tw	ist in Tub	e		Folio		Outside	Dimensions				

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Page 1

October=17-13 1:30:22 PM

WorkOrder ID: ParentItem:

108416

D3912-3

Parent Item Name:

Eyebolt Block

Start Date: 10/17/13

Required Date: 10/17/13

Start Qty: 12.00

Required Qty: 12.00

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000 303 BAR 1" X 1"	· · · · · · · · · · · · · · · · · · ·	Purchased	No			100	f	22.5300	0.208	2.6273688	للا	3-10-2	4

Loc Code Loc Oty Location MAT031 22.53 2.56 22.53 m126724

NCD		,	B. I.
NCR:	Yes	/	No

NCR: Y	'es / No		·		WORK ORDER NON-	CON	IFORM	MANCE / UP	DATE	DQA:	Date:	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap Use-as-is		ı	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo			<u>-</u>	Work Order Update]		Large Fab	Composite]	Supplier	
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	1	nitial ef Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		3109	GLY -				ei Liig	Desc	i i puon	Date	Vernication	QC IIISPECTOI
		•	•		,	AULT	CATE	GORY		•		
Landir	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Crimped at n Strip in n Bend Vaves in E	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of (on Incomplete ions Incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	st ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw				Folio			Dimensions			······································	

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DART AEROSPACE LTD	Work Order:	108416
Description: Eyebolt Block	Part Number:	D3912-3
Inspection Dwg: D3912 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.30	+/-0.030	2.301	~		Veca	6A-01
Ø0.129	+0.005/-0.001	\$0.130	1		11	11
0.50 Ref	+/-0.030	0.497	~		11	11
R0.13	+/-0.030	RO. 125	/		R-6	ref.
0.500	+/-0.010	0.496	~		H-6	31006
R0.125	+/-0.010	RO.125	~		R-6	ref.
0.63	+/-0.030	0.627	~		Vern	69-01
0.750	+0.000/-0.020	0.737	~		H-6	31006
0.38	+/-0.030	0.377			11	11
1.500	+/-0.010	1.500	~		Vern	GA-01
0.500 Pitch	+/-0.010	0.500	~		11	11
0.800	+0.000/-0.010	0.799	V		Mic	6A-03
0.400	+/-0.010	0.399	_		H-6	31006
0.516	+0.015/-0.000	0.521	~		Vern	6A-01
1.00	+/-0.030	0.991	✓ ·		U	11

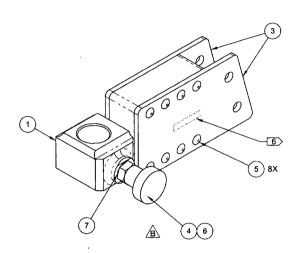
Measured by:	DAS 045	Audited by:	Preliminary Approval:	
Date:	13/10/29 289	Date: 3-10-30	Date:	

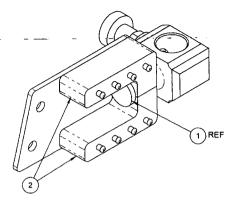
Rev	Date	Change		Revis	ed by	Approved
Α	10.06.07	New Issue		KJ	۲۸	1
В	12.05.15	Dwg Rev updated		KJ	ALL	(WIII
-			. 16		- V/)	7

ſ	ITEM .	QTY -041	P/N	DESCRIPTION	
		Х	D3912-041	EYEBOLT RECEIVER ASSY	
t	1	1	D3912-1	EYEBOLT	\dashv
Ī	2	2	D3912-3	EYEBOLT BLOCK	
Ī	3	2	D3912-5	EYEBOLT PLATE	
D [4	1	D3801-1	SPRING PLUNGER	
-	5	8	MS20615-4M20	RIVET	٦.
Ī	6	1	MS21209-F615	HELICAL	
ı	. 7	1	NAS1149F0332P	WASHER	7 4









SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

108416 ML3 13-10-27

D3912-041 EYEBOLT RECEIVER ASSY

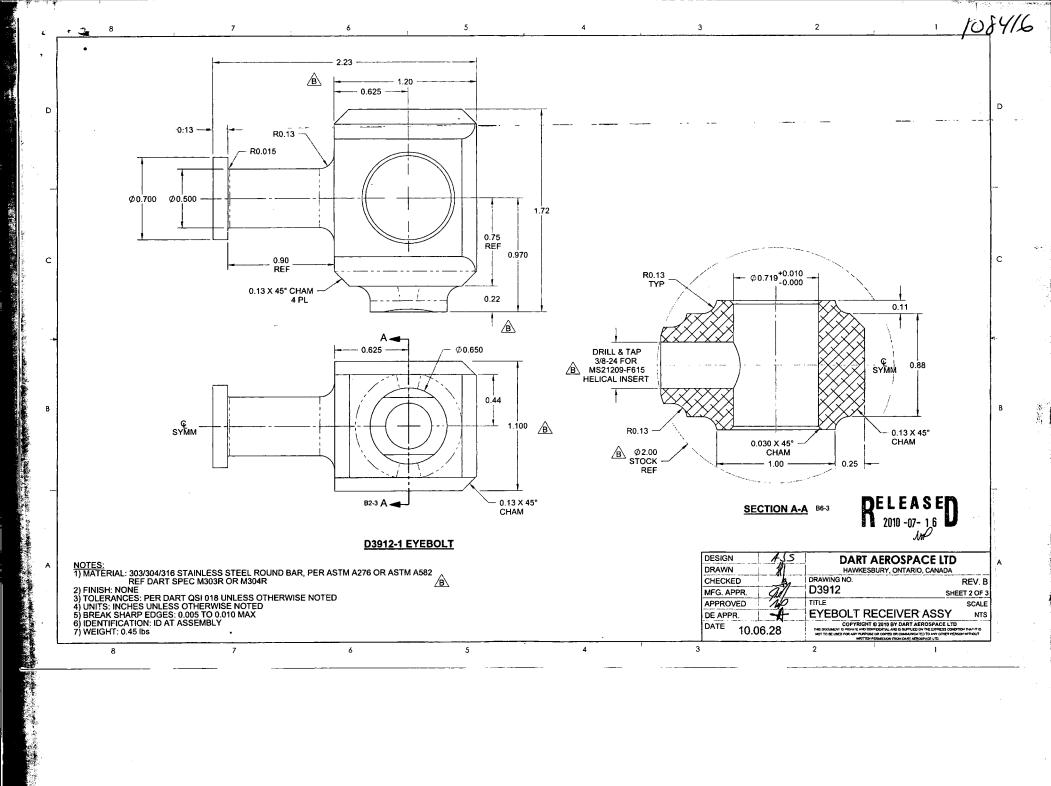
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT INK MARKER:

8

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-6615 WAS MS21209-6610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. 10.06.28 NEW ISSUE 10.03.04 Α DESCRIPTION REV. DATE

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN CHECKED DRAWING NO. REV. B D3912 MFG. APPR. SHEET 1 OF 3 TITLE APPROVED SCALE EYEBOLT RECEIVER ASSY

COPYRIGHT © 2010 BY DART AEROSPACE LTD DE APPR. NTS DATE 10.06.28



108416

0.800+0.000 Ø0.129 THRU 1.500 4 PL 0.38 0.400 0.500 PITCH 0.50 REF 1.00 0.750 +0.000 -0.020 0.500 R0.13 R0.125 TYP 0.516 +0.015 0.63

D3912-3 EYEBOLT BLOCK

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

1.500 0.500 PITCH R0.13 TYP 0.25 0.517 1.000 1.500+0.020 2.00 REF Φ -Ø0.129 Ø0.257 0.125 8 PL 2 PL REF 3.65 3.69 REF

D3912-5 EYEBOLT PLATE

DESIGN	1455	DART AEROSPACE LTD	
DRAWN	181	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	all	D3912 SHE	ET 3 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	-#	EYEBOLT RECEIVER ASSY	NTS
DATE 10.06.28		COPYRIGH: 6 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDE AND COMPENTAL AND IS SUPPLIED ON THE DOTHESS CONCE NOT TO BY USED FOR ANY PLAPPOSE OR COPYED OR COMMANICATED TO MAY OTHER PER- WORTH MEMBERSHAP BY ARRESTMENT ARRESTMENT ARRESTMENT OF THE PER- THE PERSON OF THE PERSON O	

2